

Split - A

Work Order ID 114332

114332

Page 1

Monday, June 09, 2014 1:48:24 PM

Item ID: D2144

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Hinge Doubler

Start Date: 3/04/14

Start Qty: 40.00

40

Cust Item ID:

Required Date: 3/04/14

Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan:

Date:

14-6-9

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2144

Rev D

105

0.00

105

Purchasing

Memo

0.00

Purchasing

ISSUE PO: 24577

CUT AS PER DRWG: D2144 REV D

CZ 14/10/12 40

115

Receive & Inspect for Damage & Mat'l Certs

0.00

115

Packaging

Memo

0.00

Packaging

P 14/7/4 (40)

125

QC6- Inspect dimensions to drawing

0.00

125

QC

Memo

0.00

Quality Control

DAS

16

9-89

14/07/30

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Item ID: D2144 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Hinge Doubler
 Start Date: 3/04/14 Start Qty: 40.00 *40* Cust Item ID:
 Required Date: 3/04/14 Req'd Qty: 40.00 *40* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Small Fab	0.00							
130	Small Fab	0.00							
Small Fab	Memo								
Small Fab	Deburr if necessary								
140	NC BRAKE	0.00							
140	Brake NC	0.00			DAS				
Brake NC	Memo				30				
	Form as per Dwg D2144				9-89				
	Rev: <u>D</u>								
150	QC5- Inspect part completeness to step on W/O	0.00							
150	QC	0.00							
Quality Control	Memo								

14/02/15

40

40

DAS 16 9-89

DAS 38 9-89

14/08/13

14/08/15

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Item ID: D2144 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Hinge Doubler
 Start Date: 3/04/14 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 3/04/14 Req'd Qty: 40.00 ***40*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Large Fab	Weld per dwg A/R S.S. rod Batch: <u>M116048</u> Large Fab	0.00				<u>3</u>		<u>14-08-20</u>	
Large Fab	Memo 1- Weld corner as per Dwg D2144 & QSI 004 2- Grind flush	0.00							
170 *170* QC	QC9- Inspect visual per QSI004- Fusion Welds	0.00				<u>3</u>		<u>14-08-20</u>	DAS 9 3-89
Quality Control	Memo	0.00							
180 *180* QC	QC5- Inspect part completeness to step on W/O	0.00				<u>3</u>		<u>14-08-20</u>	DAS 9 9-89
Quality Control	Memo	0.00							

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Item ID: D2144

Revision ID:

Item Name: Hinge Doubler

Start Date: 3/04/14

Start Qty: 40.00

40

Required Date: 3/04/14

Req'd Qty: 40.00

40

Reference:

Accept

N900040100

Setup

Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

White Gloss(Ref:4.3.5.1) per OSI005 4.3-Alum

0.00

190

Powdercoat

Powder Coating

Memo

0.00

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3 14-8-20 DAS 34 9.89

200

QC3- Inspect Part Finish

0.00

200

QC

Quality Control

Memo

0.00

3 DAS 38 9.89 14/08/20

210

Identify as per dwg & Stock Location: STG03

0.00

210

Packaging

Packaging

Memo

0.00

3 14-8-20

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Page 5

Item ID: D2144

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Hinge Doubler

Start Date: 3/04/14

Start Qty: 40.00

40

Cust Item ID:

Required Date: 3/04/14

Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start *NR1*

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.00

Quality Control

MLJ 14-08-21
MLJ 14-08-21

Picklist Print

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Page 1

Work Order ID: 114332

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Parent Item: D2144

D2144

Parent Item Name: Hinge Doubler

Start Date: 3/04/14

Required Date: 3/04/14

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP: D04.05.06ReformatKJ/RF
IPP Rev:E Now on Waterjet 06-10-15 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S16GA		Purchased		No		120	sf	144.8670	0.0945	4			
-----------	--	-----------	--	----	--	-----	----	----------	--------	---	--	--	--

M304S16GA

304/316 Sheet .063

CD 14/06/14

Location

Loc Qty

Loc Code

MAT020

144.867

M127821

75.567

M128423

1.2

M129192

68.1

m129545

DART AEROSPACE LTD		Work Order: 114332
Description: Hinge Bracket		Part Number: D2144
Inspection Dwg: D2144	Rev: D	Page 1 of 1

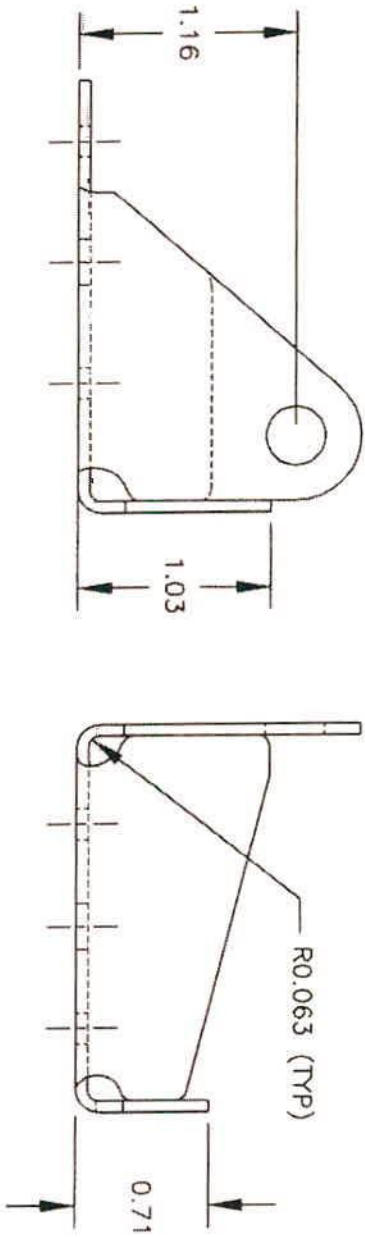
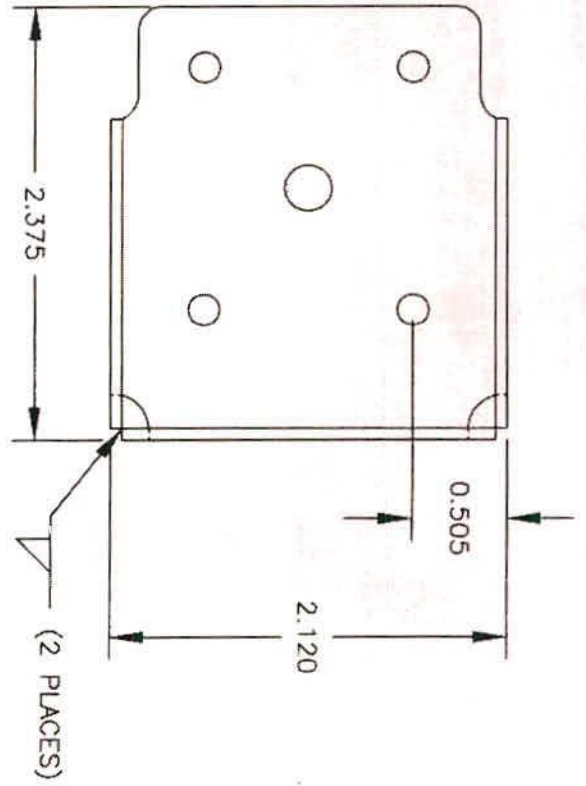
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.381	+/-0.010	3.381"	-		✓	Jkm01
3.022	+/-0.010	3.022"	-		✓	
2.468	+/-0.010	2.468"	-		✓	
1.913	+/-0.010	1.913"	-		✓	
1.555	+/-0.010	1.555"	-		✓	
4.126	+/-0.010	4.132"	-		✓	
3.465	+/-0.010	3.465"	-		✓	
0.340	+/-0.010	0.340"	-		✓	
0.625	+/-0.010	0.625"	-		✓	
1.000	+/-0.010	1.000"	-		✓	
1.083	+/-0.010	1.083"	-		✓	
1.660	+/-0.010	1.660"	-		✓	
2.312	+/-0.010	2.312"	-		✓	
2.844	+/-0.010	2.844"	-		✓	
3.294	+/-0.010	3.301"	✓		✓	
Ø0.257	+0.006/-0.001	0.258"	-		✓	
Ø0.171	+0.005/-0.001	0.172"	-		✓	
Ø0.320	+0.006/-0.001	0.324"	-		✓	
0.354	+/-0.010	0.354"	-		✓	
0.063	+/-0.010	0.058"	-		✓	

Measured by: DAS 23 Date: 14-07-29		Audited by: JB Date: 14/07/30		Prototype Approval: DAS 9-89 Date: 14/07/31		N/A N/A	
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Rev	Date	Change	Revised by	Approved
A	07.05.31	New Issue	KJ/JLM	<i>[Signature]</i>



FINISH: POWDER COAT GLOSS WHITE (4.3.5.1) PER DART OSI 005 4.3
TOLERANCES ARE PER DART OSI 018 UNLESS OTHERWISE NOTED
WELD PER DART OSI 004

RELEASED 98.10.15 AC

DART



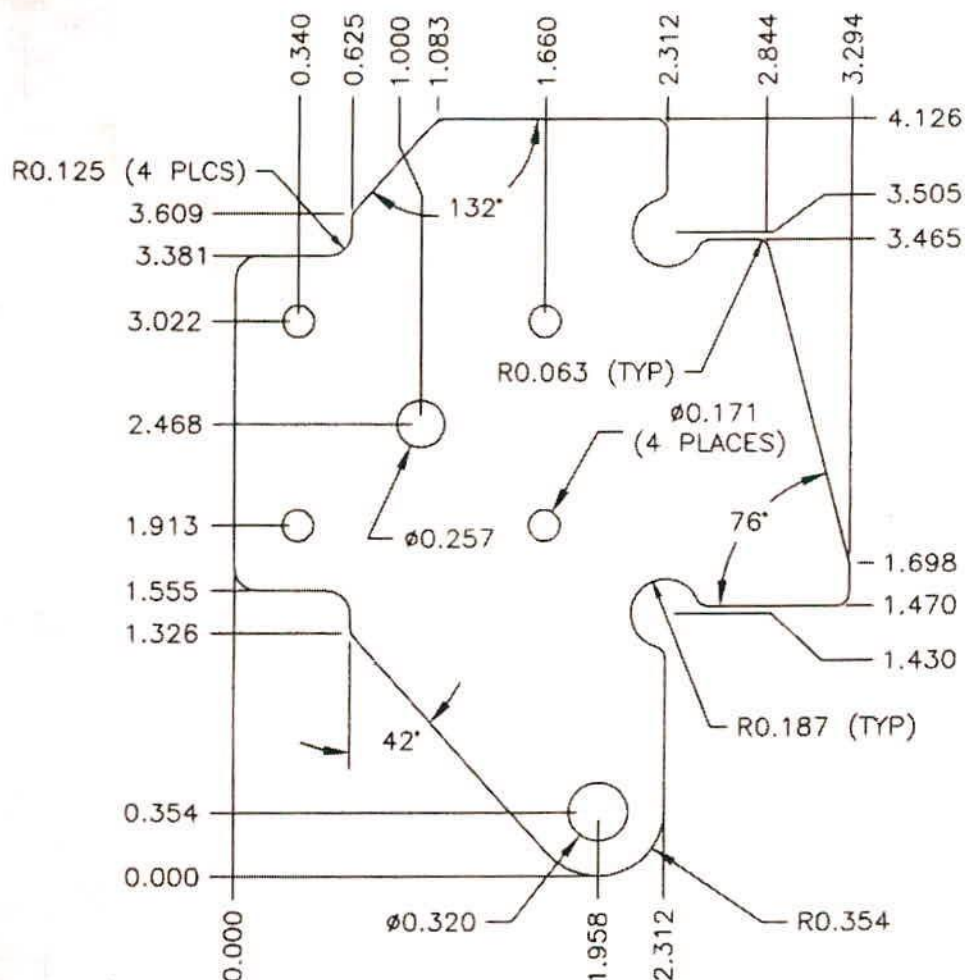
114332
ALJ
14-03-05

DESIGN BY	BW	CHECKED	DATE	98.10.08	A
DRAWN BY	KE	APPROVED	TITLE	HINGE BRACKET	95.03.17
DRAWING NO.	D2144	REV. D	SCALE	1:1	NEW ISSUE
HAWKESBURY, ONTARIO, CANADA					FLAT PATTERN LAYOUT ADDED
					98.10.08
					UPDATED DIMS AFTER BEND (TSR A917)



DESIGN BW	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED MHA	APPROVED Q	DRAWING NO. D2144	REV. D SHEET 2 OF 2
DATE 98.10.08	TITLE HINGE BRACKET		SCALE 1:1

RELEASED
98.10.15 KE



D2144 FLAT PATTERN

MATERIAL: AISI 304/316-2B SS, 0.063 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

T.P.I. INDUSTRIES INC.

148 GOODFELLOW
 DELSON, QUÉBEC J5B 1V4
 CANADA
 Tel: (450) 633-0484
 Fax: (450) 633-0879

Packing Slip

Packing Slip No.: 6177
 Date: 2014-07-02
 Page: 1

Sold to:	Ship to:
Dart Aerospace Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada	Dart Aerospace Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada
Order No.: 24577	Sold By: JONATHAN LESSARD
Shipped By:	Ship Date: 2014-07-02
Tracking No.:	

Item No.	Unit	Description	Quantity
d3564-5	Chaque	d3564-5	24
d3564-9	Chaque	d3564-9	24
d3564-11	Chaque	d3564-11	24
d3791-1	Chaque	d3791-1 wearpad	24
d3537-3	Chaque	d3537-3 wearpad	40
d3537-1	Chaque	d3537-1 wearpad	60
d3537-1	Chaque	d3537-1 wearpad	60
d3791-1	Chaque	d3791-1 wearpad	20
d2154	Chaque	d2154 bracket stud	40
d2144	Chaque	d2144 hinge doubler	40
d4095-045	Chaque	d4095-045 wearplate assy	12
d4095-043	Chaque	d4095-043	12
d4095-041	Chaque	d4095-041 wearplate assy	12
d3859-041	Chaque	d3859-041 wearplate	16
d4952-1	Chaque	d4952-1 wearplate	20
d4095-051	Chaque	d4095-051 wearplate assy	20
d4095-049	Chaque	d4095-049 wearpad	16
d4095-047	Chaque	d4095-047 wearplate assy	20
d4798-041	Chaque	d4798-041 wearplate assy	16
d4135-1	Chaque	d4135-1 wearpad	10
d4360-041	Chaque	d4360-041 wearplate assy	8
d2012-111	Chaque	d2012-111 bracket	40
d2324-5	Chaque	d2324-5 strap	40
d2947	Chaque	d2947 clamp	60
d3171-1	Chaque	d3171-1 angle bracket	20
d3463-3	Chaque	d3463-3 step	12
d3512-1	Chaque	d3512-1 wearplate	16
d3629-1	Chaque	d3629-1 bracket	20
d3955-5	Chaque	d3955-5 plate	12
d4021-5	Chaque	d4021-5 blanking plate	40
d3556-1	Chaque	d3556-1 clamp	40

Comment: Net / 30 from date of invoice 2% svc. chg. on invoices over 30 days